

ABSTRACT

A force limiting workpiece holding device for holding a workpiece in a workpiece processing assembly having a spindle and a closer that applies a force, comprises a workpiece holder slidably mounted to the spindle. The workpiece holder includes a plurality of circumferentially-spaced gripping segments that are movable between expanded and contracted positions to grip and release a workpiece. A force limiting coupling structure includes a biasing structure having a spring force. The coupling structure is operatively mountable between the workpiece holder and the closer such that a force applied by the closer to move the gripping segments of the workpiece holder between the expanded and contracted positions is transferred to the workpiece holder through the coupling structure and the biasing structure thereof, whereby a resultant force being applied to the workpiece holder by the closer is limited to the spring force of the biasing structure.